

Date: Tuesday, 8/21/2007 3:44:11 PM
 Use: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE BILLET
Job Number : 34201	
Estimate Number : 10032	
P.O. Number : <i>N/A</i>	Part Number : D6101001
This Issue : 8/21/2007 S.O. No. : <i>N/A</i>	Drawing Number : D6101 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 33679	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 9/5/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>62</i> Um: Each
Comment : Est. B 01.05.04 New Issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *4434**0207102122*

a) Description: Aluminum billet

b) 6.00" x 6.250" x 2.00" thick

c) Tolerance on length are +0.025"/-0.000" AE +/- 0.008"

(60)

d) Grain direction along 6.00" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

2.0	D6101001P	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s)
 7075-T7351 2X6X6.25

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

[Signature] 07/09/13 62

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D

ml 07/09/15 62

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/09/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:44:11 PM

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 34201

Part Number: D6101001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ml 07/09/15 62

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

62
170709/17

Job Completion



07/09/17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

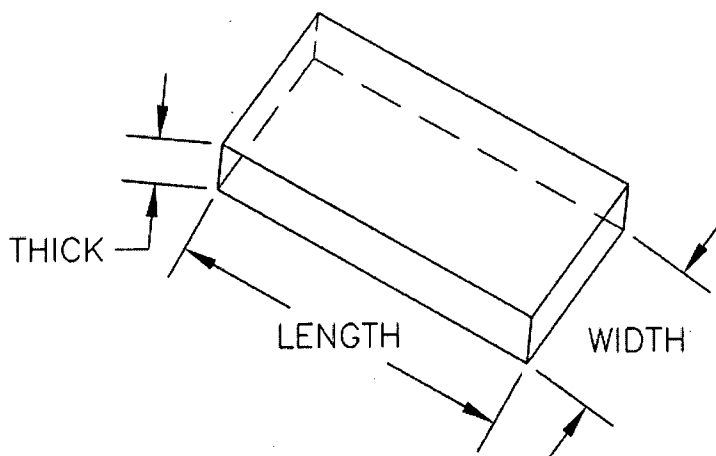
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED [Signature]	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 [Signature]



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34201

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31 555715 996666 01		A.M. CASTLE & Co. (Canada) Inc.		EXPEDIE 12 SEP 2007	
NO. COM. CLIENT-CUST. REQUISITION NO.		NO. COM. CLIENT-CUST. ORD. NO.		COMPT-ACCT. VEND-SLS TERR. EXPEDIE PAR-SHIP VIA	
4434		91037 200 40		TRUCK MANITOULIN	
ACHETEUR-PURCHASING AGENT		TELEPHONE		H/C TAXE NO. COM ORD	
LINDA LACELLE		613 632-3336		9 0 1	
VRE A-SHIP TO:		REGION LIVRAISON-DEL ZONE		F.A.B.-F.O.B.	
		C/C		PREPAID	
VENDU A-SOLD TO:		INFORMATION CREDIT CREDIT INFORMATION		ROUTE	
DART AEROSPACE LTD		R2C SEE FRANCE STATUS		01 *NL-09/0	
1270 ABERDEEN				31-NL-09/0	
HAWKESBURY		ON K6A 1K7			
INSTRUCTIONS/LIVRAISON-DELIVERY		INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)			
1N0-658568					
DESCRIPTION - ITEM 1		QTE/UNITE COM.-ORDERED		POIDS COM.-WT. ORDERED	
2.0000 PLATE 7075-T7351 ALUM 6.25" X 6.00" BLACK W/RED STRIPE		60 PCS PCS		455	
CERTIFICATE OF CONFORMANCE		BALLOTS-BUNDLES		PCES/PD EXP. SHIP	
A.M. Castle & Co. certifies that the material(s) supplied under this document will meet and conform to the specifications of the product(s) described hereon.		1 60		455	
A.M. Castle & Co. (Canada) Inc.		FORME-SHAPE		I.A.C.	
WEIGHT FOR SHIPPING PURPOSES ONLY. SEE INVOICES FOR ACCURATE BILLING WEIGHT. PLEASE SIGN AND DATE DRIVER'S COPY FOR RECEIPT OF MATERIAL AND, IF CHECKED, TEST REPORTS.		29.0885QF		6857	
INSTRUCTIONS		COULÉE INFO-HEAT INFO		QTE-QTY	
TOL: +.030"/-.000"		369178A9		54	
THICKNESS TOL.: +.030"/-.000"		388638A9		6	
GRAIN TO RUN ALONG 6.00"		INSTRUCTIONS (CONT'D.)			
PRIOR DIST/ORD: 01 996666					
		60x6.25x6.00			
DESCRIPTION - ITEM 2		QTE/UNITE COM.-ORDERED		POIDS COM.-WT. ORDERED	
TERMS AND CONDITIONS OF SALE		BALLOTS-BUNDLES		PCES/PD EXP. SHIP	
SEE DISCLAIMERS AND LIMITATIONS ON THE REVERSE SIDE		1 Box		FORME-SHAPE	
				I.A.C.	
INSTRUCTIONS		COULÉE INFO-HEAT INFO		QTE-QTY	
INSTRUCTIONS (CONT'D.)					
DESCRIPTION - ITEM 3		QTE/UNITE COM.-ORDERED		POIDS COM.-WT. ORDERED	
ALL EXCEPTIONS FOR SHORTAGE OR DAMAGE MUST BE NOTED ON THE DRIVER COPY & CUSTOMER COPY OF THE DELIVERY RECEIPTS & SIGNED BY THE DRIVER & CUSTOMER. COPY OF SUCH RECEIPT PROPERLY NOTED MUST BE SUBMITTED WITHIN 10 DAYS WHEN CREDIT IS REQUESTED.		BALLOTS-BUNDLES		PCES/PD EXP. SHIP	
				FORME-SHAPE	
				I.A.C.	
INSTRUCTIONS		COULÉE INFO-HEAT INFO		QTE-QTY	
E.P. 07/09/13					
INSTRUCTIONS (CONT'D.)					
NOM (LETTRE MOULEE)-NAME (PRINT ONLY)					
RECU PAR-RECEIVED BY					
DATE RECU-DATE RECEIVED					
				FEVILLE D'EMBALLAGE - PACKING SL	

SHIP TO:

A M CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4099234

SOLD TO:

AM CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

CUSTOMER PO NUMBER: 01-84412		WORK PACKAGE:		CUSTOMER PART NUMBER: 6857 A97075-60		SHIP RUN/LOAD ID: 100990/17		GOV'T CONTRACT NUMBER:		
KAISER ORDER NO: 1049378		LINE ITEM: 1	SHIP DATE: 6-JUN-2007	ALLOY: 7075	CLAD: BARE	TEMPER: T7351		PRODUCT DESCRIPTION: MILL FINISH PLATE		
WEIGHT SHIPPED: 2878 LB		QUANTITY: 2 PCS EST.		B/L NUMBER: 2013143		GAUGE: 2.0000 IN		WIDTH: 48.500 IN		LENGTH: 144.500 IN

Certified Specifications

AMS 4078/RevF
ASTM B 209/Rev08
BSS 7055/RevA
DPS 4.713/RevN/AmdAF
GSS16100/RevG

AMS-QQ-A-250/12
ASTM B 594/Rev08
CMMP 025/RevR
EAC MS1011/RevD
MMS 159/RevN

AMS-STD-2154
BAC 5439/RevH
CSTI 008/RevC
GAMPS 9101/RevB
PS 21211/RevK

Test Code: 4297

Test Results

Lot: 369178A9 Cast 976 Drop 49 Ingot 4

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	73.4 : 73.5 (506 : 507)	82.5 : 82.6 (431 : 432)	11.3 : 11.3

Conductivity %IACS :	41.4 Min	41.6 Max
(MS/M) :	24.0 Min	24.1 Max

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.11	0.23	1.49	0.02	2.40	0.19	5.60	0.03	0.01	0.01	TOT 0.04

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.20	0.00	2.10	0.18	5.10	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.00	0.30	2.90	0.28	6.10	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

CASTLE METALS CORP.
DATE RCVD 6/7/07
IAC 6857
APPROVED BY fw-jpgs